

Work Order ID 92046

October 22, 2012 10:02:31 AM

92046

Page 1

Item ID: D6209

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: U-Channel Extrusion

Start Date: 10/22/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/24/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 12/10/22 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D6209	A

100 0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 18200

Possible supplier: McMaster Carr

Supplier P#: 1630T14

Ensure Material Release Note is attached

CL 12/10/22 (10)

110

0.00

110

Packaging

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

CL 10/24 (10)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

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Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120 QC Quality Control	Memo	0.00	DAS 14 9-89	12/10/29		10	0		
130	Identify as per dwg & Stock Location: MAT01	0.00							
130 Packaging Packaging	Memo	0.00	DAS 14 9-89	12/10/29		10	0		
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC Quality Control	Memo	0.00							12/10/31 <i>[Signature]</i>

12-10-30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

October 22, 2012 10:02:31 AM

Page 1

Work Order ID: 92046
Parent Item: D6209
Parent Item Name: U-Channel Extrusion

Start Date: 10/22/12

Required Date: 10/24/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.06.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
1630T14 U-CHANNEL EXTRUSION		Purchased	No			110	f	0.0000	1	10		10/24/12	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

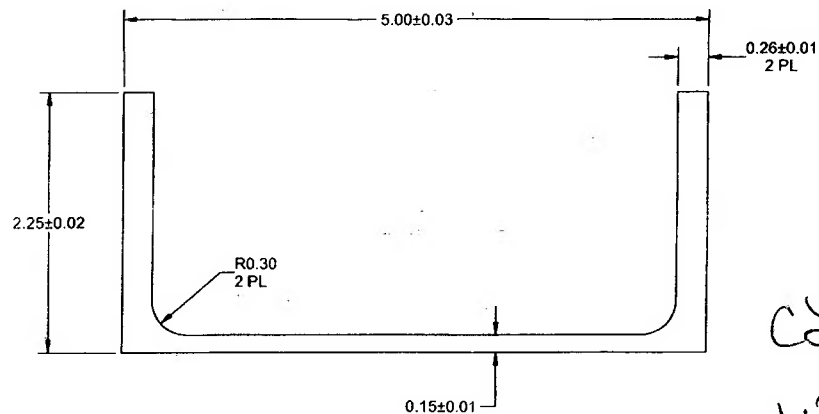
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SPECIFICATION CONTROL DRAWING



D6209-XXX EXTRUSION
WHERE "XXX" IS LENGTH IN INCHES

CY 12110122
W10:92046

RELEASED
2012-09-26

NOTES:

- 1) MATERIAL: ALUMINUM ALLOY, 6061-T6 PER ASTM B308
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.089 lb/ft
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 1630T14

A		NEW ISSUE		RP		12.06.22			
REV.		DESCRIPTION				BY		DATE	
DESIGN		RP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWN		RP							
CHECKED		RP		DRAWING NO.				REV. A	
MFG. APPR.		RP		D6209				SHEET 1 OF 1	
APPROVED		RP		TITLE				SCALE	
DE APPR.		RP		EXTRUSION				NTS	
DATE		12.06.22		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO18200**

Purchase Order Date 10/22/12

PO Print Date 10/22/12

Page Number 2 of 2

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Requisition Nbr	
Vendor Fax	330 995 9600	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 10
		Currency	USD
		FOB	Destination-Collect

4	6785T43 TZE251 TAPE CARTRIDGE 1"	10/23/12	4.00	FedEx PI collect	\$27.6800	\$110.72
		Yes	Each			

Deliver To: STORES

5	1630T14	U-CHANNEL EXTRUSION	10/23/12	10.00	FedEx PI collect	\$12.7480	\$127.48
		Yes		f			

Special Inst: AS PER DWG D6209 REV. A
B92046
MAMASTER P/N: 1630T14

PO Total: \$555.15

CERTIFICATE OF CONFORMITY
REQUIRED UPON DELIVERY

Change Nbr: 2

Change Date: 10/22/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO18200

McMaster-Carr Number
3066725-01

Page 1 of 1

10/22/2012

Line	Description	Ordered	Shipped
5	1630T14 Multipurpose Aluminum (Alloy 6061), U-Channel, 5" Base X 2-1/4" Legs, 5' Length	2 Each	2
	Unit Price:	\$63.74	
	Extended Price:	\$127.48	

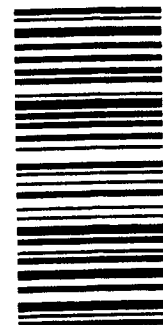
6 - 33 - 37 18 - 17 T14 2 EA 5
22 lbs

Charges for this shipment

Merchandise Amount:	\$127.48
Total:	\$127.48

Dart Aerospace Ltd

EXP
INV



22 lb
1 lin

PL

FW1RFV7E
10/22/2012
09:48/10:3:
167
Cycle 25

1140536668324

